

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027717**Date Inspected:** 05-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** William Sherwood**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of the shift this Quality Assurance Inspector (QA) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) welding and Quality Control (QC) personnel. The observations and inspections were performed as noted below:

**OBG West Drop-in Splice 13W/14W**

This QAI observed the welding of the back gouged backside of weld joint W13-W14-A2.1. The welding was being performed by Michael Jimenez in the 4G position using the Shield Metal Arc Welding (SMAW) Process at 126 amps using an E7018H4R consumable electrode.

QAI observed the welding of the back gouged backside of weld joint W13-W14-A2.8. The welding was being performed by Jeremy Dolman (ID#5042) in the 4G position using the Shield Metal Arc Welding (SMAW) Process at 129 amps using an E7018H4R consumable electrode.

This QAI observed the welding of the back gouged backside of weld joint W13-W14-A2.8. The welding was being performed by Welder Rory in the 4G position using the Shield Metal Arc Welding (SMAW) Process at 125 amps using an E7018H4R consumable electrode.

QC William Sherwood was observed by this QAI performing in-process weld inspection and QC verification using the applicable Welding Procedure Specification. This QAI observed and verified the welding and QC inspection at random intervals.

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QAI observed the continued welding of web splice on beam 13W-PP123-BW-1 in the 3G position by welder Mike Jimenez utilizing the requirements of Welding Procedure Specification AB-WPS-D15-1030-A. Welding observed by this QAI met the requirements of the Welding Procedure Specification and The American Welding Society D1.5 Bridge Welding Code.

This QAI observed Magnetic Particle Testing (MPT) performed by QC Technician William Sherwood on welds: W13-W14-A2.2 and W13-W14-PPW 123.6. QC performed the testing using Parker Contour Probe Model B300, Serial #19882. Red powder was used to provide contrast between the weld metal and base metal. No indications were noted.

This QAI performed Magnetic Particle Testing (MPT) of welds 13W-W14-A2.2, and 13W-14W-PPW123.6 at a frequency of 10% the total length. The testing was performed from the top and bottom surface of the deck plate. This QA performed the testing using Parker Contour Probe Model B300, Serial #19882. Red powder was used to provide contrast between the weld metal and base metal. No indications were noted.

### OBG Suspender Brackets West

This QAI observed the completion of welding on stiffeners x464-12A of the west side of Suspender Bracket PPE-104W. The welding was being performed by Eric Sparks in the 3G and 4G position using the Shield Metal Arc Welding (SMAW) Process at 126 amps using an E7018H4R consumable electrode.



### Summary of Conversations:

There were general conversations with Quality Control Inspector William Sherwood, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510 385 5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Daggett,Matt

Quality Assurance Inspector

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**Reviewed By:** Levell,Bill

QA Reviewer